

Date: Monday, 28/05/2007 2:25:21 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WINDOW			
Job Number	: 32366		Part Number	: D32903			
Estimate Number	: 11176		Drawing Number	: D3290 REV B			
P.O. Number	: N/A		Project Number	: N/A			
This Issue	28/05/2007	S.O. No.	: N/A		Drawing Revision	: B	
Prsht Rev.	: NC		Material	: N/A			
First Issue	16/05/2007	Type	: PURCHASED PARTS		Due Date	: 22/05/2007	
Previous Run	: 29568		Qty:	10		Um:	Each
Written By	: <i>[Signature]</i>						
Checked & Approved By	: <i>[Signature]</i>						
Comment	: Est. A 04.08.18 New issue KJ/RF						
	Est. B 06.05.09 Ecn 798 EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	THERMOFORMING	THERMOFORMING MACHINE <i>n 103735</i>
	Comment: THERMOFORMING MACHINE MAKE PER DRWG D3290 REV.B	
2.0	MACRLICS125	1/8" Polycast II Sheet
	Comment: Qty.: 3.0800 sf(s)/Unit Total : 30.8000 sf(s) 1/8" Polycast II Sheet	
3.0	QC5	INSPECT WORK TO CURRENT STEP <i>107-06-20</i>
	Comment: DIMENSIONAL CHECK Inspect dimensions as per Dwg D3290 and DT3290-3T1	
4.0	PACKAGING 1	PACKAGING RESOURCE #1 <i>107/6/21</i>
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____	<i>10</i>
5.0	QC21	FINAL INSPECTION/W/O RELEASE <i>107-06-22</i>
	Comment: FINAL INSPECTION/W/O RELEASE	<i>107-06-22</i>
	Job Completion	

Date: Wednesday, 5/16/2007 8:11:04 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: WINDOW			
Job Number	: 32366							
Estimate Number	: 11176							
P.O. Number	:			Part Number	: D32903			
This Issue	: 5/16/2007	S.O. No.	:	Drawing Number	: D3290 REV B			
Prsht Rev.	: NC			Project Number	: N/A			
First Issue	: / /	Type	: PURCHASED PARTS	Drawing Revision	: B			
Previous Run	: 29568			Material	:			
Written By	:			Due Date	: 5/22/2007			
Checked & Approved By	: <u>John</u> 05.16				Qty:	10	Um:	Each
Comment	Est.	A	04.08.18	New issue	KJ/RF			
	Est.	B	06.05.09	Ecn	798	EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description
1.0	PG	PURCHASING

Comment: PURCHASING
Issue P/O: _____
Description: D3290-3 Window
Possible Supplier: Canus
Certificate of Conformity & Process sheet are required

2.0	D32903P	Window
		Window
Comment: Qty.: 1.0000 Each(s)/Unit		Total : 10.0000 Each(s)

3.0 PACKAGING 1  PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage
Ensure certificate of conformity and process sheet are attached

4.0 QC6  DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3290 and DT3290-3T1

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				
06-07-20	3.0	1 window scrap. Very wavy in the middle of the view/window. R.C.: Bad forming/knot distortion.	Initial 06/06/20	Scrap & destroy	EP 07/06/20	07-06-20	05/07/20	07-06-20	

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WINDOW

Job Number: 32366

Part Number: D32903

Job Number:



Seq. #: Machine Or Operation:

Description:

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(10)

Comment: FINAL INSPECTION/W/O RELEASE

100716/22

Job Completion



Macylec .125" ~~100~~ M103735

07/06/04

- 1.) Mark & Trim part as per jig DT 3290-3T1 07/06/04
- 2.) DRAPE Mould part as per ~~Dwg. D3290-3 Rev B~~ and ~~Tool F1000~~ 07/06/04
- 3.) Inspect Parts QC ~~22~~ 07/06/04
- 4.) Rework Parts - (Parts re-trimmed to meet allowable tolerance) 07/06/04
- 5.) R-inspect parts ~~QC 22~~ ~~07/06/04~~ 07/06/04

Rework 2 windows 07/06/04 1h.

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

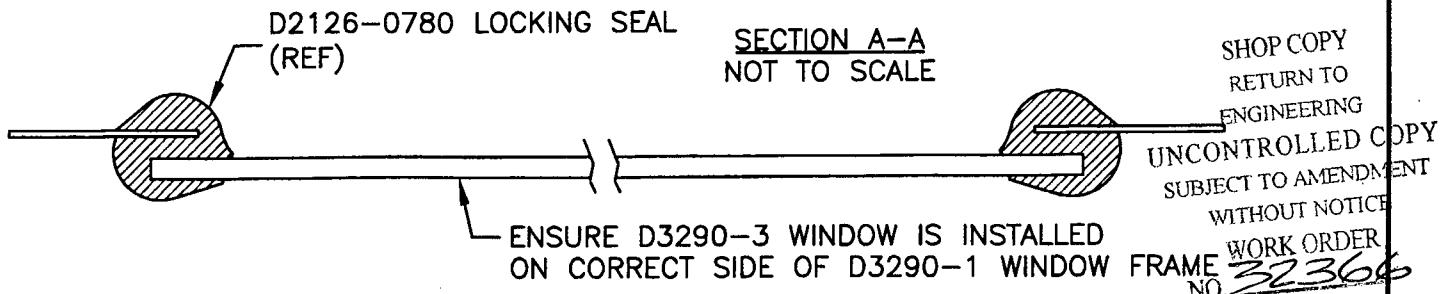
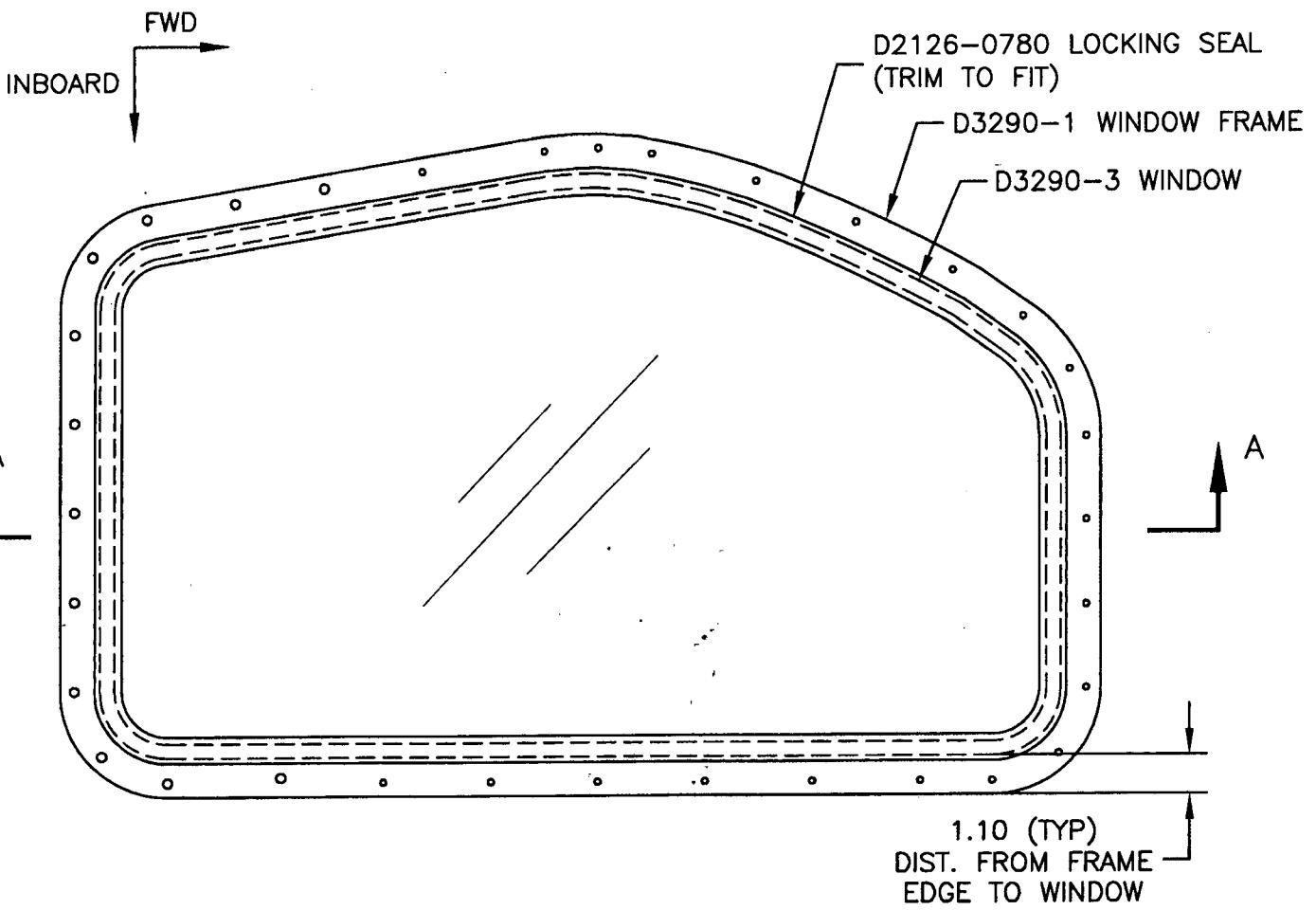
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3290
DATE 06.04.20		REV. B SHEET 1 OF 3
		TITLE REPLACEMENT WINDOW ASSEMBLY 1:5
A	04.06.14	SCALE NEW ISSUE
B	06.04.20	UPDATE MATERIAL PER NCR 029

**D3290-041**

RELEASED

06.04.20 *#***NOTES**

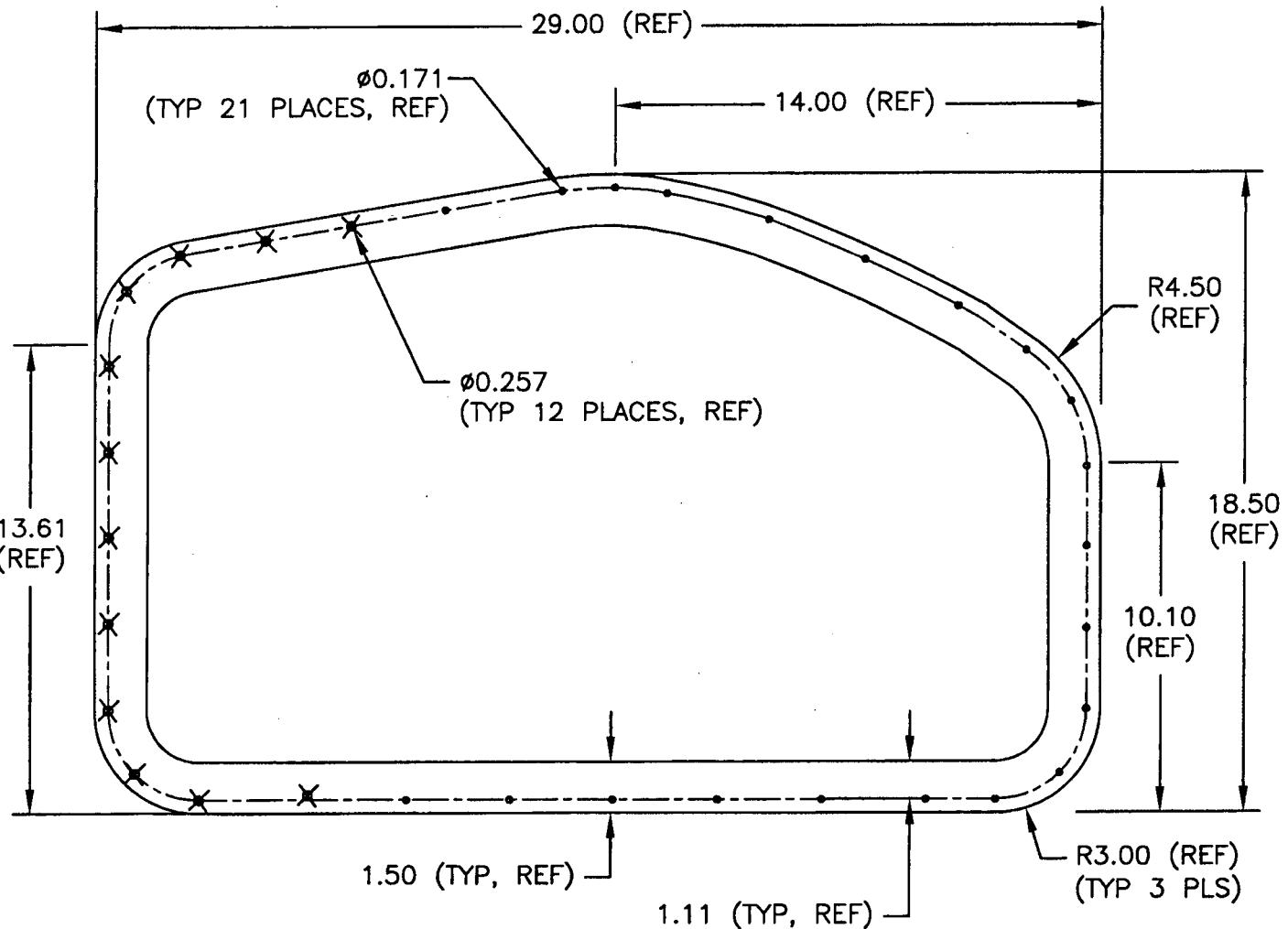
- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART

DESIGN RF	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3290	REV. B SHEET 2 OF 3
DATE 06.04.20		TITLE REPLACEMENT WINDOW ASSEMBLY	SCALE 1:5

**D3290-1 FRAME****D3290-1**

- 1) MACHINE PER DRAWING FILE "D3290-A2.DWG"
- 2) MATERIAL: 5052-H32 (QQ-A-250/8) SHEET 0.040 THICK
- 3) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
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DART

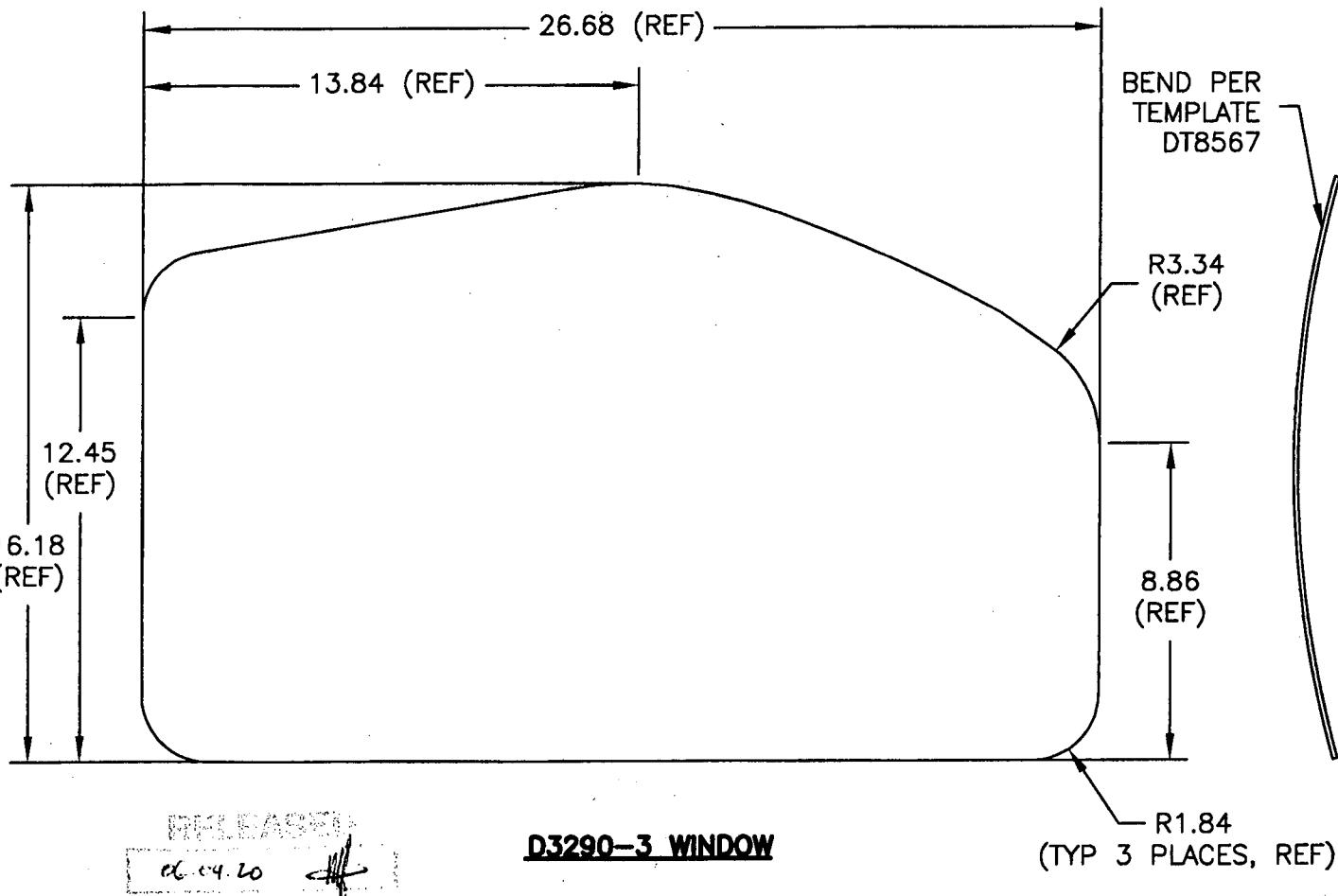
DESIGN RF	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3290
DATE 06.04.20		TITLE REPLACEMENT WINDOW ASSEMBLY

REV. B

SHEET 3 OF 3

SCALE

1:5

**D3290-3**

B 1) MATERIAL: POLCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)

2) ALL DIMENSIONS ARE IN INCHES

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) BREAK ALL SHARP EDGES 0.010 TO 0.020

5) CHECK PART USING DT3290-3T1

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